

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,8 mm



Order data

Order number	123225 3,8
GTIN	4045197844873
Item class	11E

Description

Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.

- **Clear reduction in cutting forces due to special cutter geometry.**
- **Coating for best wear resistance even at high process temperatures.**
- **Polished flutes for good chip clearance.**

A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.

Recommendation:

Maximum drilling depth:

flute length (see table) less $1.5 \times \text{nominal } \varnothing$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the $12 \times D$ drill, an initial centre drilling with NC spotting drills No. 121068 – 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123226**.

Order form **HE**: with **No. 123225 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 58.3 mm

Overall length L: 102 mm

Shank $\varnothing D_s$: 6 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.09 mm/rev.

Technical description

Number of cutting edges Z	2
Standard	Manufacturer's standard
Tolerance nominal \varnothing	h7
Flute length L_c	64 mm
Nominal $\varnothing D_c$	3.8 mm
recommended maximum drilling depth L_2	58.3 mm
Overall length L	102 mm
Shank $\varnothing D_s$	6 mm
Feed f in steel < 1100 N/mm ²	0.09 mm/rev.
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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